

Date: Thursday, 19/03/2009 4:31:09 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 46620	
Estimate Number : 12884	
P.O. Number :	Part Number : D3560044
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D3560 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 46403	Material :
Written By :	Due Date : 03/04/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JUL 09.03.19</u>	
Comment :	
Est Rev:A New Issue 07.05.24 EC	
Est Rev B ECN 987 07.10.09 EC verified by DD	
Est Rev:C ECN1048 07-12-18 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.3598 f(s)/Unit Total : 10.8780 f(s)
 6061-T6 Bar 0.50" x 5.00"
 Batch: 110550

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 15.500" long

8F 09/03/21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

PTO →

8F 09/03/21 (5)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8F 09/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-044 PAR #: N/A Fault Category: Prod/Machine Parts NCR: (Yes) No DQA: Yes Date: 07/04/30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 09/05/01

NCR: <u>46620</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/21	3.0	First Part have a Contamination Mark on the top of the part. Rc. operator error, bad origin, lack of attention.	<i>[Signature]</i>	NO replace, Scrub ↓ No mat'l to replace.	<i>[Signature]</i> 09/03/21	J.F. 09/03/23	<i>[Signature]</i> 05/04/2	<i>[Signature]</i> 10/08-23

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 46620

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/03/23

(4)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLATE B44666

09.04.28

4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/30

(66)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.04.30

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 46620

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-04-30 (4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/30 (4)

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

batch:

B41708

ES 09/04/30

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

ES 09/04/30 (4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/30 (x4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PATE

SS 09/04/30 (x4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/01 (x4)

Job Completion



mf 09-04-30

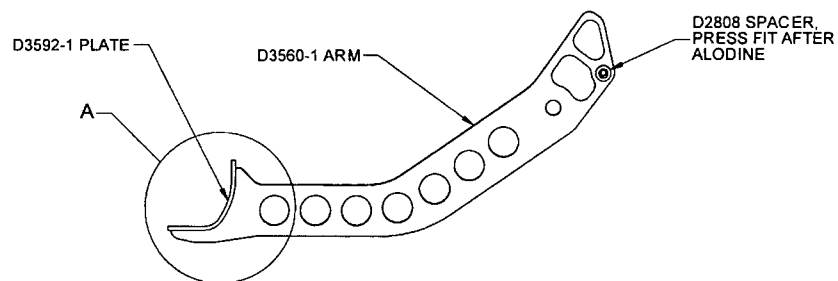
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

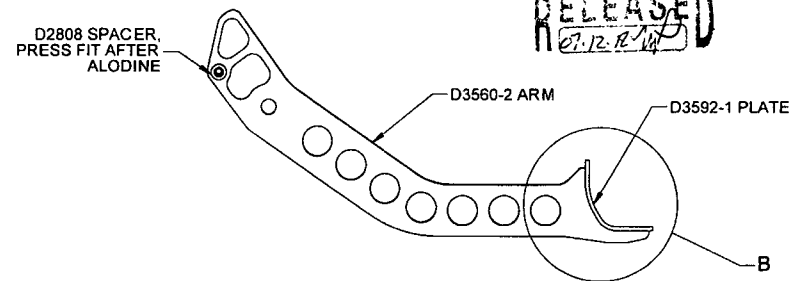
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

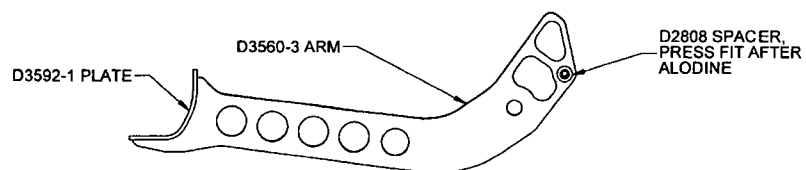
NOTE: Date & initial all entries



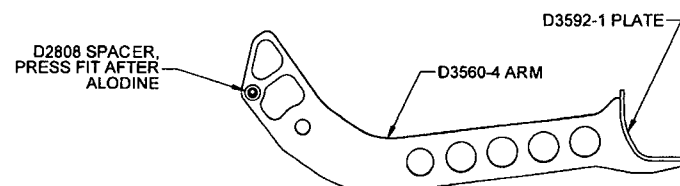
D3560-041 ARM WELDMENT



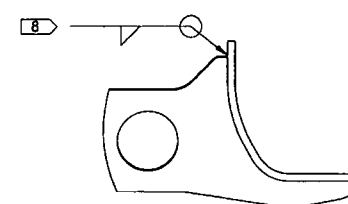
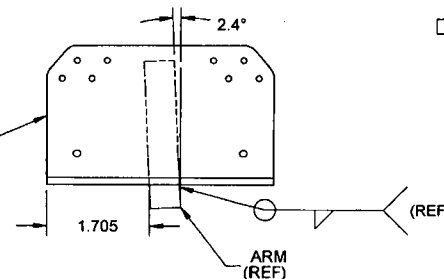
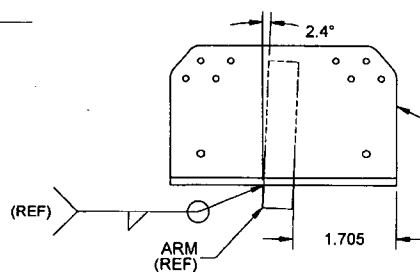
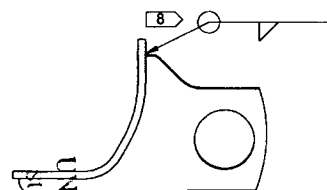
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT









D3560-044 ARM WELDMENT



DETAIL B
SCALE 1 : 2

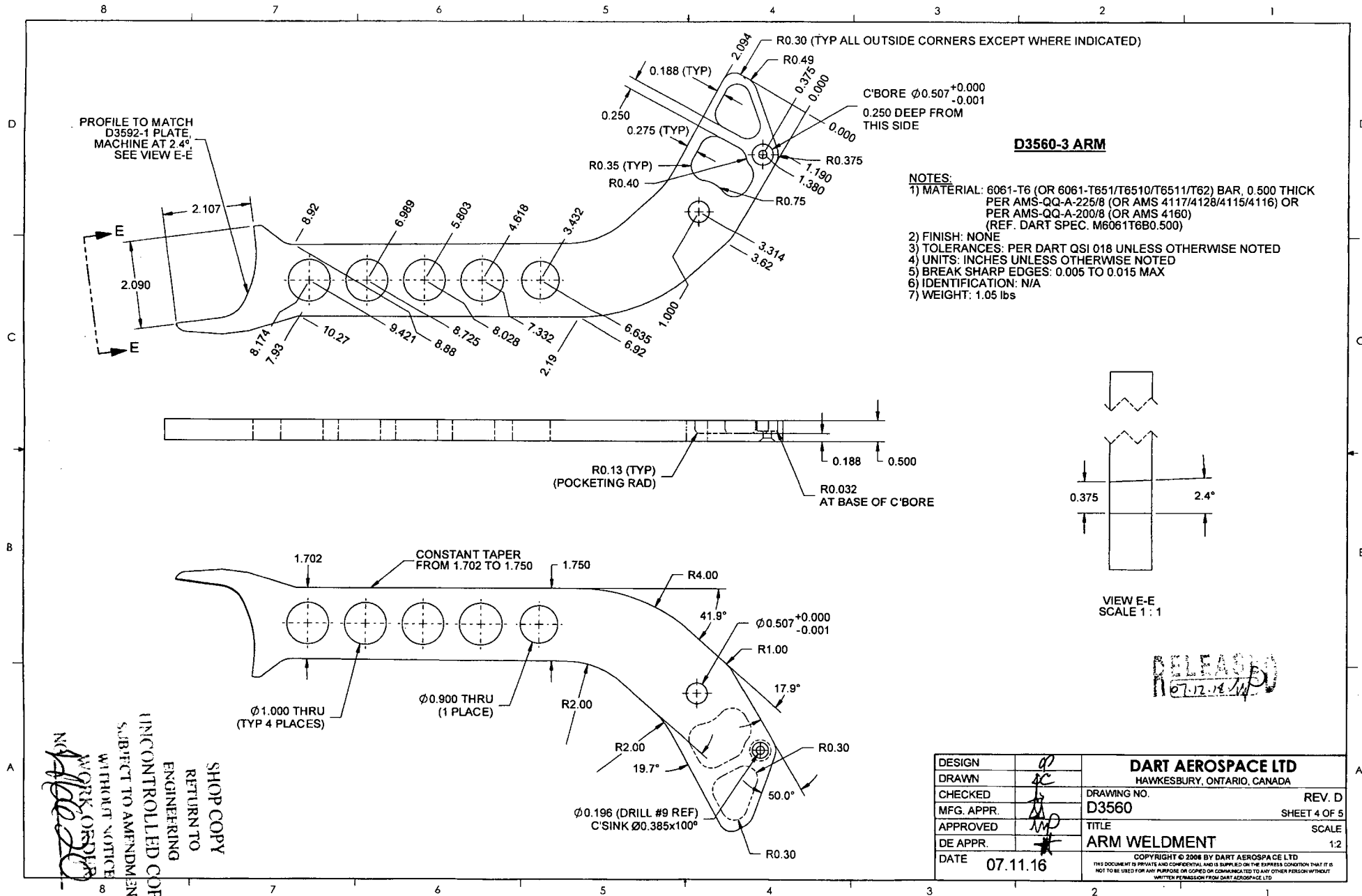
PARTS LIST

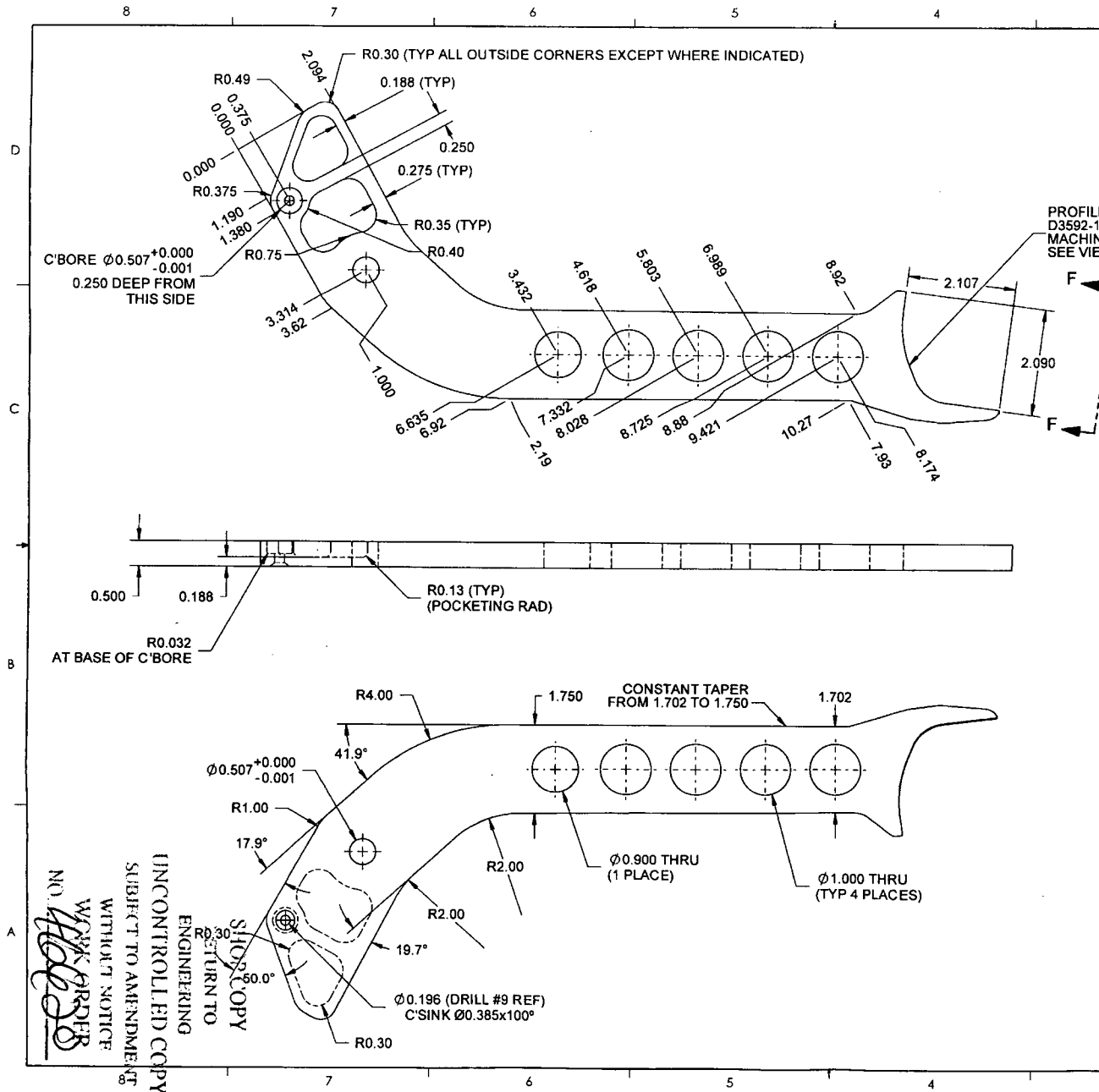
QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PI ATF

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		D3560 TITLE ARM WELDMENT	
DATE	07.11.16	COPY RIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EMPLOYED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. SHEET 1 OF 1 SCALE 1

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

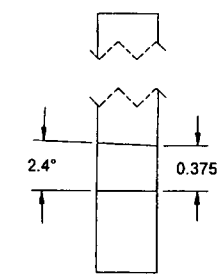




PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW F-F

D3560-4 ARM

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

RELEASED
07-12-16

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DRAWN	BC	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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